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DOCUMENT NUMBER

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REVISE AS SHOWN

# REULSE PARAGRAPH 4.7 AS SHOWN

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(U) EXPOSED SURFACES SHALL BE FINISHED USING:

PRIMER MIL-P-85582 TYPE 1, CLASS N.

OR MIL-P-23377 TYPE 1, CLASS N. PAINT WITH

MIL-C-85285 TYPE 1, COLOR 16473. USE

PROCESS SPECIFICATION G636625.

4.7 (U) EXPOSED SURFACES SHALL BE FINISHED USING:

1.0 EPOXY POLYAMIDE PER MIL-P-23377

OR 9924 WASH PRIMER

2.0 M413 (GRAY) ELASTOMERIC POLYURETHANE BASE COAT AND

3.0 A471 CHEMICLAZE II WEATHER RESISTANT TOP COAT

AS MANUFACTORED BY HUGHSON CHEMICALS, LORD CORPORATION,

ERIE, PENNSYLVANIA 16512, OR RAYTHEON ESD-APPROVED

EQUIVALENT.

SHEET	OF	3
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DATE (YYMMDD)

(See MIL-STD-480 for instructions)		i i
"is revision described below has been authorized for the document listed.	961219	OMB No 0704-0188
and reviewing this concentration and completing and reviewing the collection of information. Send comments regarding this but	or reviewing instructions, searching e. Den estimate or any other aspect of thi	risting data sources gathering and
reducing this burden to Washington Headquarters Services. Directorate for information Operations and R محصفة	eports 1215 Jefferson Davis Highwa	y Surte 1204, Arlington VA 22202.
Drice of Information and Regulatory Affairs, Office of Management and Budget, Washington, DC 20503	10.000	
RAYTHEAN F-SYSTEMS GOLETA DIVISION	2. CAGE CODE	3 NOR NO SCO0545V-2
RAYTHEON, F-SYSTEMS GOLETA DIVISION ONE SOUTH 405 CARNEROS GOLETA, CA. 93117	4. CAGE CODE	5 DOCUMENT NO
GOLETA , CA. 93117	49956	927431
LE OF DOCUMENT	7 REVISION LETTER	` '
RADOME POLARIZER, ANTENNA	(current) U	(new)
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NOTICE OF REVISION (NOR)

Form No 8(A) (1911)

SHEET C OF	NOR NO. 5000545V-		REVISE NOTES AS SHOWN
		<u>IS</u>	MASK INTERIOR SURFACE AS SHOWN.  TO EXTERIOR SURFACE APPLY DRINER MIL-P-85582 TYPE 1  CLASS N, OR MIL-P-23377 TYPE 1, CLASS N, .001 TO .002 THICK.  APPLY PAINT MIL-C-85285 TYPE 1, COLOR 16473, .001 TO .002 THICK.
NOR CONTINUATION SHEET	HEET 1	WAS	APPLY PRIMER AND PAINT DER PROCESS SPECIFICATION GG3GG25. MASK INTERIOR SURFACE AS SHOWN AND PAINT
RON	DOCUMENT NUMBER		EXTERIOR PER 928225.

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NOTICE OF REVISION (NOR)  (See MIL-STD-480 for instructions)  This revision described below has been authorized for the document listed.	DATE (YYMMDD)  96/2/9	Form Approved OMB No. 0704-0188
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RAYTHEON, E-SYSTEMS GOLETA DIVISION ONE SOUTH LOS CARNEROS OLETA, CA. 93115	2. CAGE CODE	3. NOR NO. 5C00545V-3 5 DOCUMENT NO.
ETTLE SE DOCUMENT	4 99 56	928355
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ACTIVITY AUTHORIZED TO APPROVE CHANGE SIGNATURE AND TITLE FOR GOVERNMENT		DATE (YYMMOD)

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REVISE NOTE 5 AS SHOWN

MASK INTERIOR SURFACE AS SHOWN.

TO EXTERIOR SURFACE APPLY PRIMER MIL-P-85582 TYPE 1, CLASS N

OR MIL-P-23377 TYPE 1, CLASS N .001 TO .002 THICK. APPLY PAINT

MIL-C-85285 TYPE 1 COLOR 16473, .001 TO .002 THICK. APPLY PRIMER

AND PAINT PER PROCESS SPECIFICATION 4636625.

MASK INTERIOR SURFACE AS SHOWN AND PAINT DER 928225.

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Public reporting burden for this collection of information is estimated to average 1 hou maintaining the data needed, and completing and reviewing the collection of information suggestions for reducing this burden to Washington Headquarters Services. Directors 4302 and the Office of Information and Regulatory Affairs, Office of Management and	n. Send comments regarding this burden a ite for information Operations and Report	estimate or any other aspect of this o	entipution including
RAYTHEON, E-545TEMS GOLE	ETA DIVISION	2. CAGE CODE	3. NOR NO SC00545V-4 5. DOCUMENT NO.
RAYTHEON, E-SYSTEMS GOLE ONE SOUTH LOS CARNEROS GOLETA, CA. 93/17 6. TITLE OF DOCUMENT		7. REVISION LETTER	G256363
RADOME LENS POLARIZE	R ASSY	(current) A G 8. ECP NO.	-2 435
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11. THIS SECTION FOR GOVERNMENT USE ONLY			
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DOCUMENT NUMBER

9256363

REVISE	NOTE	5	AS	SHOWN

EXTERIOR SURFACES ONLY. ADDLY DRIHER MIL-P-23377 TYPE 1, CLASS N OR MIL-P-85582 TYPE 1, CLASS N .001-.002 THICK. APPLY PAINT MIL-C-85285 TYPE 1 COLOR 16473, TOP COAT .001-.002 THICK. APPLY PRIMER AND PAINT PER PROCESS SPECIFICATION G636625.

EXTERIOR SURFACES ONLY, APPLY 929084-1 ELASTONERIC PAINT, .001-.002 THICK. APPLY 929084-5 TOP COAT .001-.002 THICK. APPLY PAINT PER 929085, APPLICATION PROCEDURE EXCEPT FOR THICKNESS. DO NOT USE WASH PRIMER 929084-2.

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REVISE (-1) PL AS SHOWN

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(See MIL-STD-480 for instructions)		Form Approved
This revision described below has been authorized for the docum	nent listed. 96/2/9	OMB No. 0704-0188
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<ul> <li>maintaining the data needed, and completing and reviewing the collection of information. Send commit</li> </ul>	ents regarding this burgen estimate or any other aspect of the	hal collection of information including
suggestions for reducing this burden to Washington Headquarters Services, Directorate for informat 4302, and the Office of Information and Requisitory Affairs. Office of Management and Budget, Wa		ity, Suite 1204, Arangton, VA 22202.
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ONE SOUTH LOS CARDEROS GOLETA, CA 931/7	A. CAGE CODE	5. DOCUMENT NO.
8. TITLE OF DOCUMENT	7, REVISION LETTER	(35430)
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# REVISE NOTE 5 AS SHOWN

MASK INTERIOR SURFACES AND FLANGE MOUNTING SURFACES, AND PAINT EXTERIOR SURFACES ONLY. APPLY PRIMER MIL-P-85582 TYPE 1 CLASS N, OR MIL-P-23377 TYPE 1, CLASS N, . OOI - . OO2 THICK . APPLY PAINT MIL-C-85285 TYPE 1 COLOR 16473, TOP COAT . OOI - . OO2 THICK.

APPLY PRIMER # PAINT PER PROCESS SPECIFICATION G636625.

DO NOT USE ANY PAINT FILLER ON POLARIZED FACE.

PAINT FILLER AND ADDED PAINT THICKNESS IS DERNITTED ON TOP

AND BOTTON EXTERIOR SURFACES.

IF NOTE IS FOIL IS ON THE SURFACE, OR IF FLAME SPRAY IS USED, PRIME COAT AFFECTED SURFACE WITH EPOKY-POLYAMIDE PAINT, PER MIL-P-23377 TYPE 1, CLASS N.

MASK INTERICR SURFACES AND FLANGE MOUNTING SURFACES AND PAINT EXTERIOR SURFACES ONLY: APPLY 929084-1 ELASTOMERIC PAINT .001-.002 THK. APPLY 929084 5 TOP COAT .001-.002 THK. APPLY PAINT PER 929085 APPLICATION PROCEDURE, EXCEPT FOR THICKNESS, DO NOT USE WASH PRIMER 92908 -- 2 OR ANY PAINT FILLER ON POLARIZER FACE. WASH PRIMER, PAINT FILLER, AND ADDED PAINT THICKNESS IS PERMITTED ON TOP AND BOTTOM EXTERIOR SURFACES. IF NOTE 13 FOIL IS ON THE SURFACE. OR IF FLAVE SPRAY IS USED, PRIME COAT AFTECTED SURFACE WITH EPOXY POLYAMIDE PAINT PER MIL-P-23377, TYPL OPTIONAL.

NOR NO. SC00545V-5

DOCUMENT NUMBER

G384301

REVISE (-1) DL AS SHOWN

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# WIP BOARD CHECK LIST

	PROGRAM: SLQ-32 A(V)	_ BLOCK(S) IMP	ACTED:	40	WBCL#
	C.E.O./M.P.C.# Sc005451/	_ DISPOSITION (	CODE:	UI	DATE 961/21/9
"X" IF REQUIRED	ACTION REQUIRED	RESPONSIBLE FUNCTIONS(S)	ESTIMATED COMPLETION	ACTUAL COMPLETION	NOTES:
	GENERATE FACTORY R.C.O.		<u> </u>	<del></del>	
	CONFIRM R.C.O. ACTIONS COMP		<del> </del> -		
	GENERATE PURCHASE REQUISITION	MAT'L CONTROL		<del> </del>	
	GENERATE PURCHASE R.C.O.	MAT'L CONTROL	12/19/96	plate	
	MODIFY MASTER SCHEDULE	MAT'L CONTROL	1-419/96	12/19/96	
	CREATE M.R.I.'S	M.S.E.			
	PREPARE 1ST ARTICLE INSP RECORD	M.S.E.		<del></del>	
	INSP PROCEDURE UPDATE	M.S.E.		<del>-</del>	
	TEST PROCEDURE UPDATE	T.S.E.	·		
	TEST SOFTWARE UPDATE	Q.C.S.E.			
	SERIALIZATION PLAN UPDATE	C.M.			
	VERIFY RETROFIT STRATEGY	M.P.M.			
	PLACE MASTER WORK ORDERS(S) ON HOLD	M.S.E.		·	
	UPDATE METHODS	M.S.E.	<del></del>		
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		NAME	-	DATE	
APPROVALS	CONFIGURATION MANAGEMENT (C M )			1 1	
(ALL REO'D)	MANUFACTURING SUPPORT ENGR (M S E )	ABAVE -		21/9/196	
	MANUF PRGRM MGMT (M P M )	Je Hora		12177196	
	PRODUCTION CONTROL (P.C.)	Mala		2119196	

API	PLICATION		REVISIONS									
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927431	AN/SLQ-32	Α	RELEASED PER CEO 06599		74-09-30	RF						
SEE ENGINEE	RING RECORDS	В	REVISED PER CEO 06794		74-11-25	AJB RF						
		С	REVISED PER CEO 11102		75-04-14	A. WEST						
		D	REVISED PER CEO 11355	dh	75-06-25	RF						
	•	Ε	REVISED PER CEO XF12448V	th	86-11-18	FG OG						
		F	REVISED PER CEO CJ00099V	ss	88-02-26	FG OG						
		G	RETYPED AND REVISED PER CEO CP00239V	lc.	91-03-11	CHPKBP						

REV STATUS	REVISION	G	G	G			0052								T	T	T
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MATERIAL:			APPROVED C.J. Burdick BY DIRECTION OF				<u> </u>	SIZE CAGE COD A 4995 SCALE NONE		[ •		845969					

## NOTES:

- 1. SCOPE. THIS SPECIFICATION CONTROL DRAWING COVERS THE REQUIREMENTS FOR NOMEX HONEYCOMB CORE MATERIAL.
- 2. RAYTHEON ITEM NUMBER. THE PART/S DEFINED BY THE RAYTHEON ITEM NUMBER IS AS FOLLOWS:

# RAYTHEON ITEM NO.

# VENDOR PART NO.

845969-1	*HRH-10-3/16-2.0 x .332 ± .006 THK
845969-2	*HRH-10-3/16-2.0 x .810 ± .006 THK
845969-3	*HRH-10-3/16-2.0 x .187 ± .005 THK
845969-4	*HRH-10-3/16-2.0 x .220 + .005 THK
845969-5	*HRH-10-3/16-2.0 x .270 + .005 THK
845969-6	*HRH-10-3/16-2.0 x .676 ± .006 THK
845969-7	*HRH-10-3/16-2.0 $\times$ .545 $\pm$ .006 THK
845969-8	*HRH-10-3/16-2.0 x .194 ± .006 THK
	*HRH-10-3/16-2.0 x .224 ± .006 THK
845969-11	*HRH-10-3/16-2.0 $\times$ .396 $\pm$ .006 THK *HRH-10-3/16-2.0 $\times$ .487 $\pm$ .006 THK
845969-12	*HRH-10-3/16-2.0 x .562 + .006 THK
845969-13	*HRH-10-3/16-2.0 x .994 ± .006 THK
845969-14	*HRH310-1/8 -1.8 $\times$ .850 $\pm$ .005 THK
845969-15	#HRH-10-0X-3/16-1.8 X .194 ±.006 THK
845969-16	#HRH-10-0X-3/16-1.8 X .224 $\pm$ .006 THK
845969-17	#HRH-10-0X-3/16-1.8 X .625 ±.006 THK
845969-18	*HRH-10-1/8-1.8 $\times$ .187 $\pm$ .005 THK
	* SUPPLIED IN 44.0 ± 2.0 X 96.0 ± 6.0 SHEETS
	# SUPPLIED IN 38.0 ± 2.0 X 96.0 ± 6.0 SHEETS

DR. SCALE CAGE CODE DRAWING NO. 845969 G

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REV G

REV G

3. SOURCE(S) OF SUPPLY. THE PART/S CALLED OUT HEREIN SHALL BE AS LISTED BY:

VENDOR NAME/ADDRESS/CAGE CODE

DESCRIBED IN CATALOG/ CATALOG SHEET NO. TSB120

HEXEL CORP.

COMMERCIAL DIVISION

15100 S. VALLEY VIEW AVENUE

LA MIRADA, CA 90638

CAGE CODE 24895

DATED: AUGUST 15, 1972

- 4. PREPARATION FOR DELIVERY. PACKAGING, PACKING, AND MARKING FOR SHIPMENT SHALL BE IN ACCORDANCE WITH MIL-STD-129. MARKING SHALL INCLUDE, BUT NOT BE LIMITED TO, THE FOLLOWING INFORMATION:
  - A) MANUFACTURER'S IDENTIFICATION
  - B) MANUFACTURER'S PART NUMBER
  - C) RAYTHEON ITEM NUMBER AND REVISION LETTER
- FAIL TO MEET THE REQUIREMENTS OF THIS SPECIFICATION, OR THE MANUFACTURER'S CATALOG DATA REFERENCED HEREIN.
- 6. DRAWING REQUIREMENTS.
  THIS DRAWING HAS BEEN PREPARED IN ACCORDANCE WITH MIL-D-1000.

APPLIC	CATION		REVISIONS						
NEXT ASSY	USED ON	LTR	DESCRIPTION	DATE	APPROVED				
:•	AN/SLQ-32	च	REVISED AND REDRAWN PER CEO XC15426V	87-06-05	787				

CONTRACT NO. NO0164-92-C-0052

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10-2735 (6-72) FILM PRINTED IN U.S.A.

	PARTS LIST (REFERENCED DOCUMENTS)								
QTY RQD	DRAWING OR SPEC NO.	TITLE	FIND NO.						
REF	MIL-STD-100	ENGINEERING DRAWING PRACTICES	6						
REF	MIL-STD-202	TEST METHODS FOR ELECTRONIC AND ELECTRICAL COMPONENT PARTS	5						
REF	MIL-E-17555	ELECTRONICS AND ELECTRICAL EQUIPMENT, PACKAGING OF	4						
REF	MIL-E-16400	ELECTRONIC EQUIPMENT, NAVAL, GENERAL SPECIFICATION FOR	3						
REF	IPC-CF-150	COPPER FOIL FOR PRINTED WIRING APPLICATION	2						
REF	IPC-TM-650	TEST METHODS	1						
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SIZE	FSCM NO. 49956	DRAWING NO	o. 845970		 REV F
SCALE		NONE	SHEET	2	 

#### NOTES:

- 1. GENERAL REQUIREMENTS
- 1.1 This drawing describes the requirements for a copper-clad polyester film.
- 2. APPLICABLE DOCUMENTS
- The documents listed in the parts list, of the issue in effect on the date of invitation for bids, form a part of this drawing to the extent specified herein. In the event of conflict, the requirements of this drawing shall govern.
- 3. CONSTRUCTION REQUIREMENTS
- Base material shall be stabilized polyester material. This material shall have a thermal shrinkage after etch of 0.8% maximum in the machine direction and 0.5% maximum in the transverse direction when tested in accordance with IPC-TM-650 Paragraph 2.2.4, Method C (24 hours at 150°F). Thickness shall be as specified in Figure 1.
- The construction laminate shall be composed of one ounce copper Type E, Class 2 or Type W, Class 7 in accordance with IPC-CF-150.
- 3.3 The base material and laminate shall be joined such that the peel strength of the copper to the polyester is a minimum of 3 lb/in when tested in accordance with IPC-TM-650, Paragraph 2.2.4.
- The unlaminated surface of the base material shall be coated with an adhesive whose thickness is as shown in Figure 1. A protective sheet shall cover this adhesive coating. The adhesive shall have a minimum peel strength of 3 lb/in when tested in accordance with IPC-TM-650, Paragraph 2.2.4.
- 3.5 There shall be no evidence of voids in the adhesive coatings.
- 3.6 There shall be no evidence of separation of laminate from the base material.

SIZE A	FSCM NO. 49956	DRAWING N	DRAWING NO. 845970	
SCALE		NONE	SHEET 3	

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- 3.8 The laminate structure shall be as shown in Figure 1.
- All materials and finishes used in this unit shall conform to the requirements of MIL-E-16400, with respect to materials, coatings and treatments, corrosion resistance, dissimilar metals, fungus-inert materials, and flammable materials.
- All materials, including finishes, adhesives, marking ink, etc., shall be resistant to the solvent solutions specified in MIL-STD-202, Method 215. The requirement for immersion of the device in the solutions does not apply.
- 3.11 Environmental Requirements
- 3.11.1 The device shall meet all specified performance requirements during and after exposure to the environmental conditions defined in Table I.
- 4. RESPONSIBILITY FOR INSPECTION

The supplier is responsible for the performance of all the inspections and tests specified. The supplier may utilize his own facilities or any commercial laboratory acceptable to RESD. Raytheon reserves the right to reject any or all parts that fail to meet the requirements of this specification, or the manufacturer's catalog data referenced herein.

# 5. PREPARATION FOR DELIVERY

Packaging, packing, and marking for shipment shall be in accordance with MIL-STD-129. Marking shall include, but not be limited to the following information:

- A) Manufacturer's identification
- B) Manufacturer's part number
- C) Raytheon item number and revision letter

SIZE	SIZE FSCM NO. 49956		DRAWING NO. 845970			REV F
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6. SUGGESTED SOURCE(S) OF SUPPLY

6.1 Circuit Materials

Division of Oak Industries, Inc.

Research Park

1101 State Road

Princeton, NJ 08540

FSCM No.: None

Part No.: CMC3808 (specify width and length)

6.2 Sheldahl
Materials Division
Northfield, MN 55057

FSCM No.: 07955

Part No.: L-5500 1 ounce x 3 mil

SIZE FSCM NO. DRAWING NO. 845970 FF SCALE NONE SHEET 5

## TABLE I - Environmental Conditions.

Temperature	-54°C to +90°C

SIZE FSCM NO. DRAWING NO. 845970 FF SCALE NONE SHEET 6

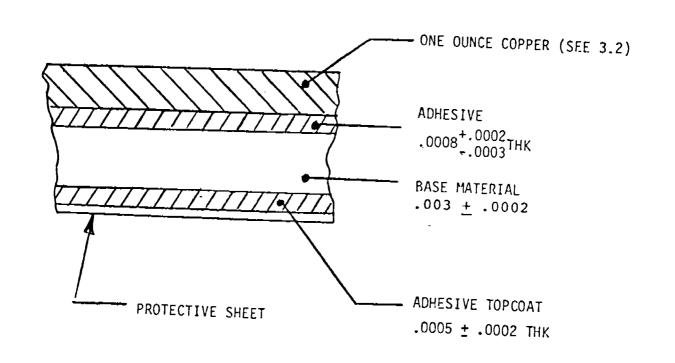


FIGURE 1
LAMINATE STRUCTURE

S	SIZE FSCM NO. 49956		o. Drawing	DRAWING NO 45970			
so	ALE		NONE	SHEET 7			

APPL	ICATION	REVISIONS						
NEXT ASSY	USED ON	LTR	DESCRIPTION	DATE	APPROVED			
928357	AN/SLQ-32(V)	A	RELEASED PER CEO 06951	20DEC	GO.			
928358		В		3/JAN75				
		С	REVISED PER CEO 17590	LE JULY TE	R.F.			
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INDEX	SHT	/	Ν	3	4	5

- 1.0 SCOPE.
- THIS SPECIFICATION ESTABLISHED THE ACCEPTABLE PROCESSING
  MATERIAL REQUIREMENTS AND PROCEDURAL OUTLINE FOR FABRICATION
  OF MEANDERLINE OR LEAPNER-TYPE POLARIZERS USING COPPER-CLAD
  MYLAR OR OTHER DIELECTRIC MATERIAL. EQUIVALENT ALTERNATE
  PROCESSES ACCEPTABLE.

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MATERIAL:	APPROVED  BY DIRECTION OF		SIZE A	49956					
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10-0700 (\$/68) VELLUM 10-0701 (\$/68) GRID VELLUM 10-0702 (\$/68) FILM

2.	0	MATERIALS	REQUIRED
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- 2.1 BASIC POLARIZER BOARD MATERIAL AS SPECIFIED ON APPLICABLE DRAWING.
- 2.2 CLEANING MATERIALS
  - \* TARNISH REMOVER ''WONDER BAR'' HARD-SILICONE RUBBER ABRASIVE ERASER (MFD. BY W.D. DORAN, INC)
  - \*SURFACE CLEANSER SCRUB CLEANER NO.11 (MFD. BY SHIPLEY)
  - \*DEIONIZED OR DISTILLED WATER
- 2.3 PHOTO-RESIST CHEMICALS (MFD BY SHIPLEY)
  - \*RESIST AZ111 FOR SPRAY COATING
    - AZ1350J FOR ROLLER COATING
  - \* ETCHANT AMONIUM PERSULFATE, COMMERCIAL GRADE OR FERRIC CHLORIDE, COMMERCIAL GRADE.
  - \*RESIST DEVELOPER 303 DEVELOPER
  - \*RESIST STRIPPER ACETONE, COMMERCIAL GRADE
- 3. TOOLS AND EQUIPMENT REQUIRED.
- FILM POSITIVE SUPPLIED AS A BASIC TOOL IN ACCORDANCE WITH PART DRAWING.
- FACILITY SUITABLE FOR PROCESSING MATERIALS EQUIVALENT TO THE PROCEDURE BELOW.
- 4.0 PROCEDURE
- 4.1 SURFACE PREPARATION

PRIOR TO APPLICATION OF PHOTO-RESIST MATERIAL,
THE COPPER CLAD SURFACES OF THE POLARIZER BOARD
MATERIAL MUST BE THROUGHLY CLEANED AS-FOLLOWS
TO A WATER "BREAK-FREE" CONDITION (NO FORMATION
OF WATER DROPLETS WHEN RINSED).

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SCALE		REV	C	SHEET	2 OF 5		

- 4.1.1 REMOVE COPPER TARNISH BY SCRUBBING THE COPPER SURFACE
  WITH A HARD-SILICONE RUBBER ABRASIVE (WONDER-BAR, MFD BY
  W.D. DORAN, INC). CAUTION: USE CARE IN APPLYING PRESSURE
  TO AVOID WRINKLING COPPER CLAD SURFACE.
- 4.1.2 WASH ALL COPPER SURFACES WITH SHIPLEY NO. 11 SCRUB CLEANER.
- 4.1.3 RINSE ALL SURFACES WITH DEIONIZED OR DISTILLED WATER.
- REPEAT 4.1.2 AND 4.1.3 UNTIL A WATER BREAK-FREE CONDITION
  EXISTS WITH SHEETING OF WATER ON CLEANED SURFACES ( NO
  WATER DROPLETS). TO REMOVE RESIDUAL PARTICLES, WIPE DOWN
  SURFACES USING REAGENT GRADE ALCOHOL AND A LINT-FREE
  PAPER TOWEL. RINSE PER 4.1.3 AND BLOW DRAY WITH CLEAN AIR.
- 4.2 PHOTO-RESIST APPLICATION- (ROOM LIGHTS TO BE YELLOW ONLY).
- APPLY PHOTO-RESIST TO ENTIRE COPPER CLAD SURFACE BY
  SPRAYING WITH AZILL RESIST. NOTE: IF REQUIRED BY ENGINEERING FOR BETTER LINE DEFINITION, USE AZI350J RESIST
  AND APPLY BY ROLLER COATING. TO MINIMIZE DUST PARTICLES,
  USE ANTI-STATIC BRUSH BEFORE APPLYING RESIST.
- OVEN DRY FOR 10 MINUTES AT 80°C, THEN MATE COPPER CLAD

  BOARD TO FILM MASTER PER PRINT, AND EXPOSE TO WHITE LIGHT

  (LIGHT BOX) FOR TWO MINUTES MINIMUM.
- DEVELOPER. SUBMERGE ENTIRE PHOTO RESIST COATED COPPER-CLAD SURFACE IN 303 DEVELOPER (MFD BY SHIPLEY) REMOVE,
  RINSE IN DISTILLED OR DEIONIZED WATER AND BLOW DRY WITH
  CLEAN AIR.

NOTE: IF BOARD MATERIAL IS DOUBLE SIDED, MASK OFF OPPOSITE (NON-COATED) SIDE USING MASKING TAPE PRIOR TO ETCHING.

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# 4.2.4 ETCHING

SUBMERGE ENTIRE BOARD IN AMONIUM PER SULFATE
TO DISSOLVE AWAY UNPROTECTED COPPER (APPROXIMATELY
1-1/2 TO 2-1/2 MINUTES DEPENDING ON STRENGTH OF
ETCHANT). (ETCHANT TANK TEMPERATURE TO BE 105°
±2°F). RINSE BOARD WITH DISTILLED/DEIONIZED WATER.
BLOW DRY WITH CLEAN AIR.

# 4.2.5 DOUBLE-SIDED BOARDS

- 4.2.5.1 DRILL THE FOUR CORNER HOLES (TARGETS) TO ESTABLISH REGISTRATION DATUMS PER PRINT REQUIREMENTS.
- 4.2.5.2 REMOVE MASKING TAPE FROM NON-ETCHED SIDE OF BOARD AND REPEAT PROCEDURES 4.2.1 THROUGH 4.2.4 FOR THAT SIDE USING THE DATUM HOLES TO REGISTER (LOCATE) THE FILM MASTER.
- 4.2.6 AS A FINAL STEP, REMOVE THE PHOTO-RESIST FROM THE REMAINING COPPER-CLAD CIRCUITRY BY DISSOLVING WITH ACETONE, COMMERCIAL GRADE.
- 5. QUALITY ASSURANCE PROVISIONS.
- 5.1 VISUALLY INSPECT GENERAL APPEARANCE OF BOTH SIDES FOR QUALITY OF WORKMANSHIP.
- 5.2 SURFACES SHALL BE FREE OF CONTAMINANTS AND RESIDUE.
- 5.3 INCOMPLETE OR OVERETCH CONDITIONS SHALL BE CAUSE FOR REJECTION. (i.e.: LINE WIDTH ETCH FACTOR SHALL NOT EXCEED 1.1.) WHEREIN ETCH FACTOR EQUALS PLATING THICKNESS DIVIDED BY EDGE UNDERCUT.
- 5.4 PIN HOLES SHALL NOT EXCEED .005 INCH DIAMETER. A
  TOTAL PIN HOLE COUNT OF 4 OR MORE PER LINEAR INCH
  ALONG ANY MEANDERLINE CIRCUIT\_SHALL BE CAUSE FOR
  REJECTION.

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 CODE IDENT NO.
 DRAWING NO.

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 SHEET 4 OF 5

- 5.5 SCRATCHES SHALL NOT BE DEEPER THAN 50% OF THE COPPER THICKNESS (QUALITY OF WORKMANSHIP TO BE A BASIC GUIDE).
  BURRS, NICKS, PITS, AND PROJECTIONS ON CIRCUITRY SHALL NOT EXCEED .003 INCH PROJECTION.
- 5.6 RESIDUAL METAL SPOTS SHALL NOT EXCEED .016 INCH DIAMETER AND SHALL BE LIMITED TO A COUNT OF 4 PER SQUARE INCH.

## 5.7 OPEN CIRCUIT

A MAXIMUM OF 3 BREAKS PER MEANDERLINE CIRCUIT IS ALLOW-ABLE WHERE A BREAK IS NOT MORE THAN ONE MEANDERLINE WIDTH IN LENGTH. A MAXIMUM OF 3 BREAKS WITHIN A 4.00 INCH DIAMETER CIRCLE IS ALLOWED WHERE A BREAK IS NO MORE THAN FOUR MEANDERLINE WIDTHS IN LENGTH. FOR LARGER BREAKS, (UP TO ONE HALF OF A COMPLETE MEANDERLINE CYCLE) A MAXIMUM OF ONE BREAK PER CIRCUIT IS ALLOWED.

- 6. PREPARATION FOR DELIVERY.
- 6.1 DO NOT HANDLE THE PANELS EXCEPT BY THE EDGES.
- 6.2 PACKAGING SHALL BE POLYETHYLENE BAGS OR EQUAL.
- 6.3 THE MARKING OF PACKAGES SHALL BE IN ACCORDANCE WITH THE DRAWING AND MARKING SHALL INCLUDE, BUT NOT BE LIMITED TO, THE FOLLOWING INFORMATION:

RAYTHEON FSCM NUMBER: 49956
RAYTHEON PART NUMBER AND REVISION LETTER

APPLICATION			REVISIONS							
NEXT ASSY	USED ON	LTR	DESCRIPTION	DESCRIPTION						
·	AN/SLQ-32	A	RELEASED PER CEO	15625	1-24-78	83				
		В	REVISED PER CEO CO1475		80.01.10	R7				
		С	REVISED PER CEO CO0782V	<u> </u>	80.01.10	-				
		D	REVISED PER CEO CO1882V	pcf	82-10-02					
		E	REVISED PER CEO C13072V	рп	A					
		F	REVISED PER CEO XC16318V	jcs		12.				

TOLERANCES: ANGLES ± FRACTIONS ± 3 PLACE DECIMALS ± 2 PLACE DECIMALS ± 1 PLACE DECIMALS ±	CH APP D	<b>Q</b> 0	Holo	2 t	1/2	23/78 23/78 23/78		COD	.E	NG; RIZ	RA ERS	DO	ME	HEON COMPANY NGTON. MASS. 02173  , RADOME  G NO. 928225
TOLERANCES: ANGLES ±	CH A P D	R R R	Hok	1	1/2	23/78	DRAWI	PAII PO	E NTI OLA E IDEI	NG; RIZ	RA ERS	DO	ME	, RADOME
TOLERANCES: ANGLES ± FRACTIONS ± 3 PLACE DECIMALS ± 2 PLACE DECIMALS ±	CH A P D	R R R	Hok	1	1/2	23/78		PAI	e NTI	NG;	RA	DO	XII	NGTON. MASS. 02173
TOLERANCES: ANGLES ± FRACTIONS ± 3 PLACE DECIMALS ±	СН	K)	Hol	1	1/2	23/78		PAI	e NTI	NG;	RA	DO	XII	NGTON. MASS. 02173
TOLERANCES: ANGLES ± FRACTIONS ± 3 PLACE DECIMALS ±	СН	IK	· 1	<del>, ,</del>		7-5		NG TITL	.E			LE	XII	NGTON. MASS. 02173
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- 1.0 SCOPE
- 1.1 THIS SPECIFICATION COVERS THE PROCEDURES AND REQUIREMENTS FOR PAINTING RADOMES AND RADOME-POLARIZERS.
- 2.0 PROCEDURE
- 2.1 SURFACE PREPARATION
- 2.1.1 THE SURFACE SHALL BE SCUFF SANDED WITH NO. 320 SANDPAPER TO REMOVE THE GLOSSY FINISH.
- 2.1.2 THE SANDING DUST SHALL BE REMOVED BY WIPING WITH A CLEAN CLOTH AND THE SURFACE WASHED WITH A HYDROCARBON SOLVENT (COLD).
- 2.1.3 MASK ALL SURFACES NOT TO BE PAINTED.
- 2.1.4 KEEP SURFACE FREE OF ALL CONTAMINATES UNTIL PAINTED. PAINT AS SOON AFTER SURFACE PREPARATION AS POSSIBLE, NOT MORE THAN 8 HOURS.
- 2.2 PRIMER APPLICATION (9924 HUGHSON)
- 2.2.1 CHEMGLAZE WASH PRIMER 9924 IS SUPPLIED EITHER IN PRE-MEASURED KITS OR IN BULK CONTAINERS. FOR KITS, POUR THE ENTIRE CONTENTS OF PART "B" INTO PART "A".

FOR BULK, MIX AS FOLLOWS:

	WEIGHT	VOLUME
PART A	1.12	1.0
PART B	_1.0	1.0
	2.12	2.0

2.2.2 MIX WELL AND ALLOW TO STAND FOR 15 MINUTES PRIOR TO USE. POT LIFE IS EIGHT HOURS MAXIMUM. REMIX IMMEDIATELY BEFORE USE.

	SIZE A	49956		DRAWING NO. 928225
_	SCALE	NONE	REV B	SHEET 2

- 2.2.3 THINNING WITH ONE PINT MEK, MIBK, OR HUGHSON THINNER B2318-42 PER GALLON OF PRIMER MAY BE DESIRABLE.
- 2.2.4 PRIMER CAN BE APPLIED BY EITHER AIR OR AIRLESS SPRAY EQUIPMENT (SEE HUGHSON GUIDELINE 131B FOR TYPICAL EQUIPMENT). AMBIENT AND SUBSTRATE SURFACE TEMPERATURE MUST BE GREATER THAN 60°F.
- 2.2.5 PRIMER SHOULD BE APPLIED IN SINGLE PASSES WITH ABOUT A 50% OVERLAP. HOLD GUN 8 TO 10 INCHES FROM SURFACE MAKING PARALLEL PASSES AND SPRAY. .002 TO .003 INCHES WET FOR A .00025 TO .0004 INCHES DRY FILM THICK-NESS. THE DESIRED DRY FILM THICKNESS WILL BE ACHIEVED WHEN THE FILM IS CONTINUOUS, BUT MOTTLED AND TRANSLUCENT.
- 2.2.6 PRIMER WILL NORMALLY DRY-TO-TOUCH IN 1/2 TO 1 HOUR AND MAY BE ELASTO-MERIC COATED IN ONE HOUR, BUT MUST BE ELASTOMERIC COATED WITHIN 8 HOUR
- 2.2.7 SEE HUGHSON BULLETIN 7039F FOR PRECAUTIONARY INFORMATION.
- 2.3 PAINT APPLICATION (M431 HUGHSON)
- 2.3.1 CHEMGLAZE M431 IS SUPPLIED EITHER IN KITS OR IN BULK, FOR KITS, MIX THE ENTIRE CONTENTS OF PARTS A AND B. FOR BULK MIX TWO PARTS RESIN, BY VOLUME, (PART A) TO ONE PART CURING AGENT (PART B). PROPER MIXING RATIOS ARE NECESSARY.
- 2.3.2 THINNING MAY BE ACCOMPLISHED BY EITHER 10~15% CHEMGLAZE THINNER 9951 OR BY ZYLENE AND TOLULENE MIXED 1:1, MAX 15%.
- 2.3.3 PAINT CAN BE APPLIED BY EITHER AIRLESS OR AIR SPRAY EQUIPMENT.

  AMBIENT AND SUBSTRATE SURFACE TEMPERATURES MUST BE GREATER THAN 60°F.
- 2.3.4 APPLY LIGHT FLASHCOAT AND LET STAND FOR 30 MINUTES.

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SCALE	NONE	REV	F	SHEET	3	<del></del>		

- 2.3.5 A MULTIPLE PASS SPRAY TECHNIQUE WITH EACH PASS AT A 90-DEGREE ANGLE TO THE PREVIOUS COAT IS ADVISED WITH THE FINAL DRY COAT THICKNESS OF M431 TO BE BETWEEN 0.002 AND 0.003 INCHES.
- FULL CURE OF THE ELASTOMERIC COATING IS 7 DAYS AT ROOM TEMPERATURE. THE TOP COATING (929084-5 ) MAY BE APPLIED OVER THE ELASTOMERIC COATING AFTER 4 HOURS MINIMUM AT ROOM TEMPERATURE.
- 2.3.6.1 THE FILM SHALL PROVIDE A SMOOTH TEXTURE AND SHOW NO PUNNING, SAGGING OR FOGGING AS A WET FILM.
- 2.3.6.2 THE DRY FILM SHALL BE A SMOOTH, UNIFORM, TOUGH RUBBER FILM SHOWING NO DUSTING, MOTILING, COLOR SEPARATION, BUBBLING, WRINKLING, STREAKING, PIN HOLDING, CRATERING, BLUSHING, BLOOMING, OR SILKING. A PEBBLY OR ROUGH FINISH SHALL BE CAUSE FOR REJECTION.
- 2.3.7 SEE HUGHSON BULLETIN 7062E FOR PRECAUTIONARY MEASURES AND CLEANUP INFORMATION.
- 2.4 TOP COAT, WEATHER RESISTANT (929084-5).
- 2.4.1 929084-5 IS A SINGLE PACKAGE COATING THAT WILL "AIR DRY" BY REACTING WITH MOISTURE IN THE AIR.
- 2.4.2 THINNING: CHEMGLAZE THINNER 9951, TOLUENE, XYLENE OR CELLOSOLVE ACETATE, UP TO 25 PERCENT BY VOLUME MAY BE USED. THE SOLVENIS USED IN THINNING SHOULD BE OF URETHANE GRADE.
- 2.4.3 THE TOP COAT CAN BE APPLIED BY EITHER AIRLESS OR AIR SPRAY EQUIPMENT. THE COATING IS FORMULATED PRIMARILY FOR SPRAY APPLICATION. TOP COAT SHOULD BE SPRAYED IN A CROSS PATTERN. A LIGHT MIST (TACK) COAT SHOULD BE APPLIED AND FOLLOWED WITH A FULL WET COAT.

RAYTHEON COLEXINGTON MASS	02173		
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- 2.4.4 RECOAT TIMES: RECOATING REQUIRES THREE TO FOUR HOURS MINIMUM LAYOVER AT ROOM TEMPERATURE WITH 30 TO 60 PERCENT RELATIVE HUMIDITY AND GOOD AIR CIRCULATION. USE OF CATALYSTS CAN SHORTEN RECOAT TIMES. RECOATING SHOULD BE ACCOMPLISHED WITHIN 24 HOURS.
- 2.4.5 CATALYSTS: CHEMGLAZE CATALYSTS 9986 MAY BE USED AT 1 TO 3 PERCENT BY WEIGHT TO ACCELERATE CURE TIME.
- 2.4.6 SEE HUCHSON BULLETIN #DS10-7061H FOR CLEAN-UP INFORMATION, TECHNICAL DATA, AND PRECAUTIONARY MEASURES.
- 2.4.7 THE DRY COAT THICKNESS OF THE TOPCOAT SHALL BE BETWEEN .001 AND .002 INCH.
- 3.0 INSPECTION
- 3.1 THE FILM SHALL PROVIDE A SMOOTH TEXTURE AND SHOW NO RUNNING, SAGGING OR FOGGING AS A WET FILM.
- THE DRY FILM SHALL BE A SMOOTH, UNIFORM, TOUGH RUBBER FILM SHOWING NO DUSTING, MOTTLING, COLOR SEPARATION, BUBBLING, WRINKLING, STREAKING, PIN HOLDING, CRATERING, BLUSHING, BLOOMING, OR SILKING, A PEBBLY OR ROUGH FINISH SHALL BE CAUSE FOR REJECTION.

	RAYTHEON COMPANY LEXINGTON MASS 02173				
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APPLICATION		REVISIONS							
NEXT ASSY	USED ON	. LTR	DESCRIPTION	DATE	APPROVED				
1	AN/SLQ-32	A RELEASED PER CEO 1488	RELEASED PER CEO 14884	12-14-77					
		В	REVISED PER CEO 17590	26,064	P.T.				
		c	REVISED PER CEO XC16721V th	88.11.09	KW				

CONTRACT NO. NOO164-92-C-0052 **REV LTR REV STATUS** C **SPECIFICATION** OF SHEETS 2 SHEET NO. 4 CONTROL DRAWING UNLESS OTHERWISE SPECIFIED CONTR NO. DIMENSIONS ARE IN INCHES RAYTHEON RAYTHEON COMPANY TOLERANCES: ANGLES ± DR J. HURST LEXINGTON, MASS. 02173 2 DX.77 FRACTIONS ± CHK DRAWING TITLE 3 PLACE DECIMALS ± 2 DEC 77 LAMINATING PROCEDURES, RADOME 9 Dec77 2 PLACE DECIMALS ± POLARIZERS ... 1 PLACE DECIMALS ± MATERIAL: SIZE CODE IDENT NO. 17/13/17 DRAWING NO. 49956 Α 928227 SCALE 1 OF 4 SHEET 10-2735 (6-72) FILM PRINTED IN U.S.A.

- 1.0 SCOPE
- 1.1 THIS SPECIFICATION COVERS THE PROCEDURES FOR BONDING MEANDERLINE POLARIZER SHEETS IN THE CONSTRUCTION OF 5 SHEET RADOME POLARIZERS.
- 2.0 MATERIALS.
- PROCESSED PER RAYTHEON PROCESS SPECIFICATION 847541.
- 2.2 EPOXY RESIN, EPON 828, PER RAYTHEON SCD 230-6003.
- 2.3 REACTIVE RESIN, VERSAMID 140, PER RAYTHEON SCD 929143.
- 2.4 THIXOTROPIC ADDITIVE, CAB-O-SIL GRADE M-5 PER MIL-S-14760.
- 2.5 PLASTIC HONEYCOMB CORE MATERIAL PER RAYTHEON SCD 845969.
- 3.0 SURFACE PREPARATION.

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and the second

- 3.1 MYLAR
- 3.1.1 MATERIAL MUST BE HANDLED TO PREVENT SURFACE CONTAMINATION.
- 3.1.2 ON SIDE OPPOSITE ETCHED MEANDERLINES, REMOVE PROTECTIVE SHEET. CARE MUST BE EXERCISED SO AS NOT TO ABRIDE OR DISTURB OPPOSITE SURFACE.
- 3.2 CORE MATERIAL
- 3.2.1 STORE HONEYCOMB CORE MATERIAL TO PREVENT CONTAMINATION.

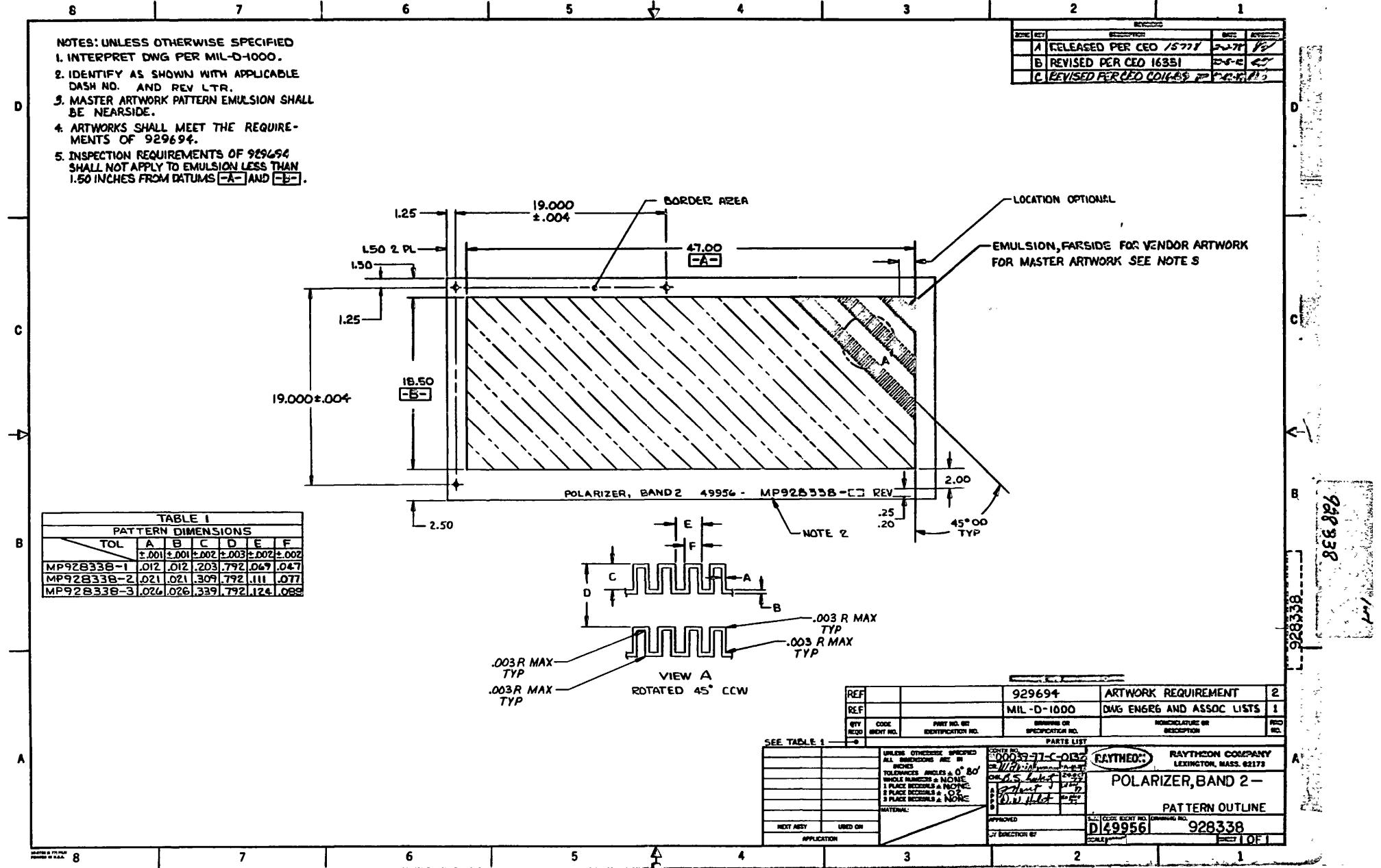
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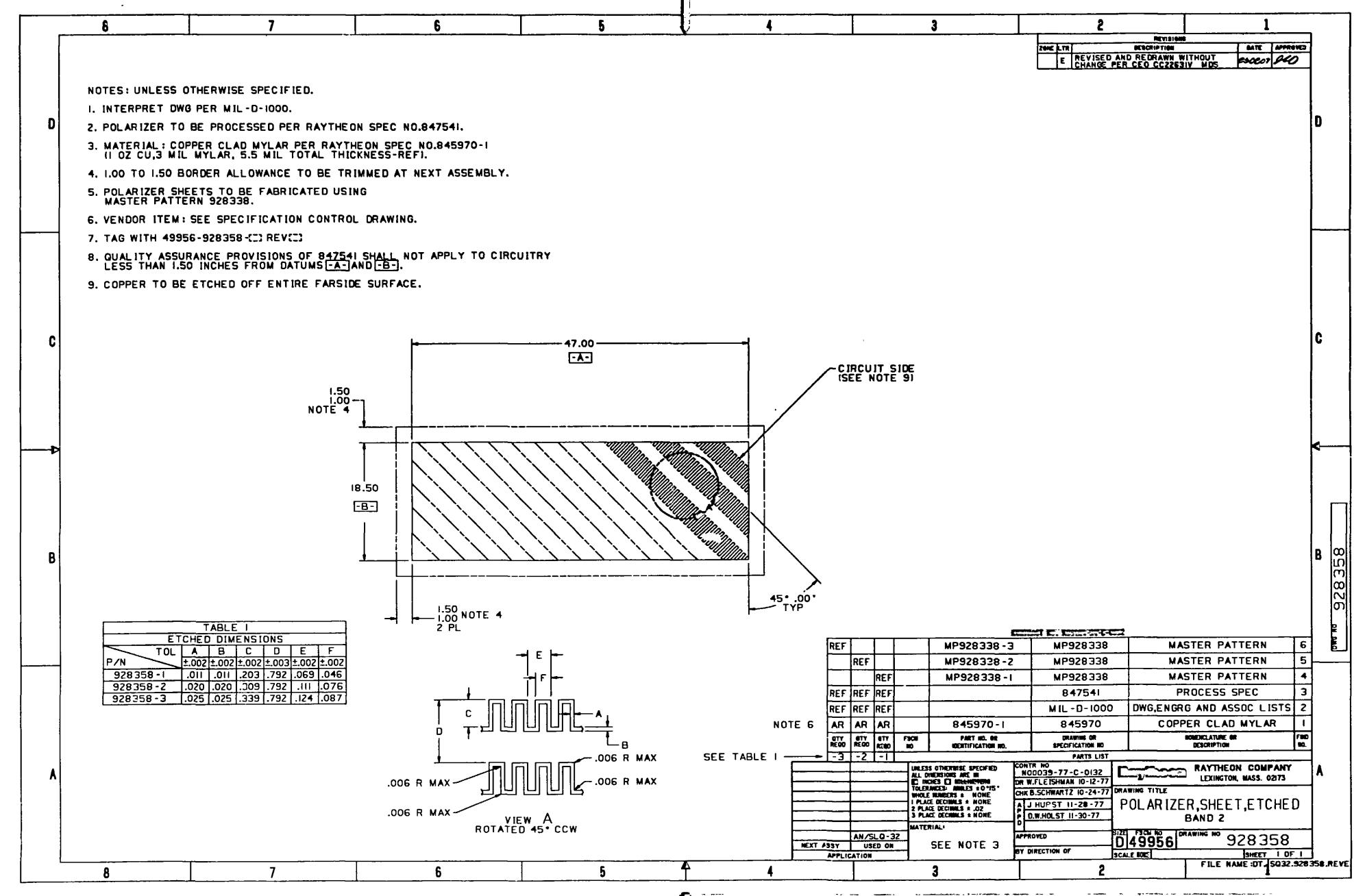
- 3.3 RADOME SHELL.
- 3.3.1 SCUFF SAND INTERIOR SURFACE WITH NO. 320 PAPER TO REMOVE GLOSSY FINISH
- 3.3.2 REMOVE SANDING DUST BY WIPING WITH A CLEAN CLOTH AND WASHING WITH MEK.
- 4.0 ADHESIVE PREPARATION.
- 4.1 MEASURE BY WEIGHT
  65 PARTS EPON 828
  35 PARTS VERSAMID 140
- 4.2 THOROUGHLY MIX EPON 828 AND VERSAMID 140 IN MEASURED PROPORTIONS OF 4.1 ABOVE.
- 4.3 ADDITION OF CAB-O-SIL UP TO A MAX OF 1% BY WEIGHT IS PERMITTED.
- 4.4 MAXIMUM POT LIFE IS 1 HOUR.
- 4.5 MIXED ADHESIVE SYSTEM TO BE APPLIED WITH CONVENTIONAL ROLL APPLICATOR.
- 5.0 LAMINATING PROCEDURE.
- CATOR. BUILDUP OF ADHESIVE TO BE 0.001 TO 0.003 THICK ON EXTERIOR EDGES AND NOT TO WICK INTO CELLS MORE THAN 0.010.
- 5.2 LAYERS OF ADHESIVE COATED HONEYCOMB CORE AND MYLAR POLARIZER SUB-STRATES TO BE ARRANGED PER GOVERNING DRAWING WITH NO FOLDS OR WRINKLES.
- LAMINATE WITH HEAT AND PRESSURE. TEMP OF ADHESIVE TO BE BETWEEN 110°F AND 125°F FOR A MINIMUM OF 1 HOUR. PRESSURE TO BE MAINTAINED AT 8-14 PSI THROUGHOUT CYCLE INCLUDING COOLING TO ROOM AMBIENT TEMP.

SIZE	CODE IDENT NO.		DRAW	/ING NO.
LA	499	56		928227
SCALE	NONE	REV	A	SHEET 3

- 6.0 INSPECTION.
- 6.1 VISUAL INSPECTION.
- 6.1.1 LAMINATE SHALL BE FREE FROM UNCURED OR UNBONDED AREAS, ADHESIVE POCKETS, AREAS LACKING ADHESIVE, TACKINESS, EXCESS SURFACE ADHESIVE, DELAMINATION, AIR OR GAS POCKETS.
- 6.2 BOND SAMPLES.
- 6.2.1 BOND SAMPLES SHALL BE PROVIDED AS NECESSARY TO INSURE PROPER ADHESION QUALITY.

SIZE	CODE IDE	DRAW	DRAWING NO.					
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### RAYTHEON COMPANY

LEXINGTON, MASS, 02173

DATE

16 Dec. 77

FUNCTION

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CODE IDENT NO. SPEC NO.

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DATE

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TYPE OF SPEC

FSC 8010

### MATERIAL SPECIFICATION

APPROVED

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61. 1

TITLE OF SPEC

**FUNCTION** 

WRITER

### POLYURETHANE COATING

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SHEET NO.

REV STATUS OF SHEETS

Raytheon
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Raytheon Company Lexington MA 02173 fscm no. 49956 SPEC NO. 929084

2 SHEET OF

rev M

1. SCOPE

1.1 <u>Scope</u>. This specification defines the requirements for a polyurethane coating system for use on radomes and radomepolarizers.

### 1.2 Classification

Type 1 Two component elastomeric system.

Type 2 Single component top coat.

### APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on the date for bid or proposal, form a part of this specification to the extent specified herein.

### **SPECIFICATIONS**

### Federal

TT-M-261

Methyl ethyl Ketone (for use in organic coatings)

TT-T-548

Toluene, Technical

TT-X-916

Xylene (for use in organic coatings)

<u>Military</u>

MIL-P-116

Preservation, Method of

### **STANDARDS**

### <u>Federal</u>

FED-STD-141

Paint, Varnish, and Related Coatings, Method Std.

Materials; Method of Inspection, No. 141

Sampling, and Testing

### <u>Military</u>

MIL-STD-129

Marking for Shipment and Storage

#### **OTHER**

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American Society for Testing and Materials

ASTM D 412

Rubber, Methods of Tension Testing of

ASTM D 1475

Density of Paint, Varnish, Lacquer, and Coatings.

Test for

ASTM D 2369

Volatile Content of Paints, Test for

ASTM D 3278

Flash Point for Liquids, Test for

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Dandh	Raytheon (	Company	FSCM NO.	SPEC NO. 9:	29084
Rayth	Lexington I		49956	3 SHEET OF	rev N
2.1	APPLICABLE DOCUMENT RAYTHEON COMPANY 929085	•	f 929084 Polyu	rethane Coa	ting for
3.	REQUIREMENTS.				
3.1	coating which will resin and phosporic	material shall be a be applied over a to acid wash primer. ane coating for top	wo part modifi Type 2 materi	ed polyviny	l butyral
3.1.1	The properties of t	he primer shall be	as specified i	n Table I.	
3.1.2	The properties of t as listed in Table	he Type 1 elastomer II.	ic polyurethar	e coating s	hall be
3.1.3	The properties of t listed in Table III	the Type 1 elastomer	ic polyurethar	e film shal	l be as
3.1.4	The properties of t Table IV.	he Type 2 polyureth	ane coating sh	all be as s	hown in
3.1.5		of the materials s the topcoat 0.002			g 0.00025
3.1.6 	The materials shall other foreign mater	be free from lumps	, aggregates,	visible dir	t and
3.1.7	The shelf life for follow:	the materials (minim	num from date	of shipment	) is as
İ	Raytheon Cont			<u>Shelf Life</u>	
1	929084-1 (P		431	l year	
	929084-1 (P	•	201	6 Mos.	
	929084-2		924A	6 Mos.	
1	929084-3 929084-4		954	N/A	
	929084-4 929084-5		951	N/A	
۱.	323004-0	A <sup>4</sup>	<del>1</del> 71	l year	

When stored at or below  $25^{\circ}\text{C}$  (77°F) in unopened containers.

Raytheon

Raytheon Company Lexington MA 02173 FSCM NO. 49956

SPEC NO. 929084

SHEET REV N

TABLE I.
Typical Properties of Wash Primer

Properties	Applicable Method in Fed. Test Method Std. Number 141	Mixture	Part A	Part B
Color		Red	Red	Clear
Viscosity Brook- field LVT cps	4287	100	1000-5000	5 Тур
Flash Point			15.6°C	22°C
(Pensky. Martens Closed Cup)			(60°F)	(73°F)
Weight (lbs/gal)	4184.1	8.3	8.6 - 9.0	7.8 - 8.1
% Solids by weight	4041 (or Lord Test Method 3C)	18	31 - 36	-

TABLE II.

Typical Properties of Type 1 Polyurethane Coating.

Properties	Applicable Test Method	Mixture	Part A	Part B
Color		Gray	Gray	Amber
Viscosity Brook- field LVT ps	FTM 141 No. 4287	3000 CPS	5000-20000	-
Flash Point	ASTM D 3278	-	34ºC(93ºF)	43.3°C (110°F)
Weight (lbs/gal)	FTM 141 No. 4184.1	8.2	8.3 - 8.7	6.9 - 7.1
% Solids (Amine Content) by weight	Lord Test Method #70	46	70-76%	8.75 to 9.25

# Raytheon

Raytheon Company Lexington MA 02173 FSCM NO. 49956

SPEC NO. 929084

5 SHEET REV N

TABLE III.
Typical Film Properties of Cured Polyurethane

Properties	Test Method	Nominal Value
Tensile at Break PSI	ASTM-D-412	5000
Elongation at Break %	ASTM-D-412	500

TABLE IV.
Typical Properties of Type 2 Topcoat

Properties	Applicable Test Method	Value
Solids: (%) by Weight	Lord Test Method 3G, Modified ASTM-D-2369	53.7 to 56.7
by Volume		41%
Theoretical Coverage (sq ft)	at 1 mil dry	660
Viscosity (cps)	Brookfield LVT, #2 Spindle, @ at 30 rpm	100 to 400
Weight (lb/gal)	ASTM-D-1475	9.2 to 9.6
60° Gloss (min)		85
Flash Point (°F)	ASTM-D-3278	25.5 (78)
Solvent System (Typical constituents)	Xylene, Toluene, n-Butyl Acetate, Methyl Isobutyl Ketone, Propylene Glycol ether Acetate	

Raytheon Company Lexington MA 02173

FSCM NO. 49956

SPEC NO. 929084 SHEET 6 OF

REV М

4. QUALITY ASSURANCE PROVISIONS.

- The manufacturer shall submit a certification of compliance (Raytheon 4.1 Form 50-372) with each shipment to certify that the materials are manufactured to the requirements of this specification.
- 4.2 Raytheon ESD reserves the right to perform any acceptance tests deemed necessary to assure that the material conforms to the requirements specified herein.
- 5. PREPARATION FOR DELIVERY.
- 5.1 Packaging. The preservation, packaging and packing shall be in accordance with MIL-P-116, Method III.
- 5.2 Marking. The marking of packages and exterior containers shall be in accordance with MIL-STD-129. Marking shall include, but not be limited to, the following information:
  - Manufacturer's name and CAGE CODE. Α.
  - Materials tradename and Part No.
  - C. Net weight or volume
  - Lot number, batch number, and date of manufacture. D.
  - Shelf life or storage limitations.
  - F. Raytheon Control Number and Revision Letter, as an option.
- 6. NOTES
- 6.1 Approved Source(s) of Supply. Only the material specified herein, when procured from vendor(s) listed hereon, is approved for use. No change to the product shall be made without prior authorization in writing from Raytheon ESD or the Naval Electronics Systems Command.

Raytheon
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Raytheon Company Lexington MA 02173

49956

FSCM NO.

929084 7 SHEET REV M

6.1.1 Approved Materials.

Raytheon Part No.	Description	Hugson Chemicals Part No.
929084-1	Polyurethane Coating, Type 1	Chemglase M431/M201
929084-2	Wash Primer	Chemglaze 9924
929084-3	Thinner	9954
929084-4	Thinner	9951
929084-5	Polyurethane Coating, Type 2	Chemglase II. A471 (Gray)

- 6.1.2 Approved Manufacturers.
- 6.1.2.1 Lord Corporation, Chemical Products Group 2000 West Grandview Blvd.

Erie, PA

16512

CAGE CODE:

30676

- 6.2 <u>Mixing Instruction</u>.
- 6.2.1 Primer
- 6.2.1.1 Thoroughly mix part A before removing it from its container.

Rayth	Raytheon Company	FSCM NO.	SPEC NO. 929084
	Lexington MA 02173	49956	8 SHEET REV M
6.2.1.2	Mix the primer components in the fo	llowing ratio.	
	<u>Parts by We</u>	<u>ight</u> <u>Parts</u>	by Volume
	Part A 121		1
	Part B 110		1
4	For kits, pour the entire contents	of Part "B" into	Part "A".
6.2.1.3	Thoroughly mix the resin components prior to use.	, and allow to	stand for 15 minutes
6.2.1.4	When thinning is required, Methyl E Hughson Thinner B2318-42, or other	thyl Ketone (MEI suitable solven	() per TT-M-261, ts, may be used.
6.2.1.5	The gun and uncured resin shall be Toluene, or equivalent.	cleaned with Me	thyl Ethyl Ketone,
6.2.1.6	The pot life of the mixed primer is	8 hours.	
6.2.1.7	Allow the wash primer coat to air d temperature before applying the Typ		
6.2.2	Elastomeric Coating, Type 1.		
6.2.2.1	Thoroughly mix part A (M431) before	removing it fro	om its container.
6.2.2.2	Mix the Type 1 components in the fo	llowing ratio. <u>by Volume</u>	
	Part A (M431)	3	
	Part B (M201)	1	
),	For kits, pour the entire contents	of Part "B" into	Part "A".
6.2.3	Thoroughly mix the resin components	and use.	
6.2.2.4	When thinning is required, Toluene (equal parts) or Chemglaze thinner	per TT-T-548 and 9951 may be used	l Xylene per TT-X-916 I.

The gun and uncured resin shall be cleaned with Methyl Ethyl Ketone,

Toluene, Xylene or equivalent.

FRINTISK AME.

6.2.2.5

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Raytheon Company Lexington MA 02173 FSCM NO. 49956

SPEC NO. 929084

- 6.2.2.6 The pot life of the mixed coating is 2 hours.
- 6.2.2.7 Cure using one of the following cycles.
- 6.2.2.7.1 Cure at room temperature for 7 days. Parts may be handled after 6 hours at room temperature.
- 6.2.2.7.2 Dry at room temperature for 2 hours minimum, and cure for 2 to 3 hours at 93 124°C (220 255°F).
- 6.2.2.7.3 Dry at room temperature for 2 hours minimum, and cure for 6 to 8 hours at 66 82°C (150 180°F).
- 6:3 Topcoat, Type 2.
- 6.3.1 Thoroughly stir the contents of the can.
- 6.3.1.1 When thinning is required, a maximum of 25% by volume Xylene, Toluene, or -4 thinner may be used.
- 6.3.2 The gun and the unused resin may be cleaned by using Methyl Ethyl Ketone, Acetone, Toluene, or -4 thinner.
- 6.3.3 The thinned material shall be used within 16 hours.
- 6.3.4 Apply a light mist coat followed by a wet coat.
- 6.3.5 Type 2 material relies upon atmospheric moisture to affect a cure. Do not apply when the relative humidity is less than 30% or greater than 60%.
- 6.3.6 Recoating shall be done between 4 and 24 hours.
- 6.4 See Raytheon Process Specification 929085 for detailed instructions.

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CODE IDENT NO. SPEC NO. 49956 SHEET

SPEC NO. 929085

SHEET 7

REV G

TYPE OF SPEC

### PROCESS SPECIFICATION

TITLE OF SPEC

APPLICATION OF 929084 POLYURETHANE COATING FOR RADOMES

FUNCTION	APPROVED	DAT	Έ	FUNCTION	APPROVED		DATE	<u> </u>
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l. SCOPE

- 1.1 This specification established the process for the coating of radomes and radome polarizers with 929084 polyurethane resins and primer. The coating system is composed of a wash primer, followed by a base coating (Type 1) followed by a final top coating (Type 2).
- APPLICABLE DOCUMENTS.
- 2.1 The following documents shall form a part of this specification to the extent specified herein.

### Specifications

### Federal

TT-I-735	Isopropyl Alcohol
TT-M-261	Methyl Ethyl Ketone (for use in organic coatings).
TT-T-548	Toluene, Technical
TT-X-916	Xylene (for use in organic coatings)

### Raytheon

929084

Polyurethane Coating

- 2.2 In the event of conflict between this specification and referenced documents, this specification shall govern.
- 3. REQUIREMENTS
- 3.1 Equipment. The equipment used to process and apply the elastomeric polyurethane coating materials shall be as specified in 3.1.1 through 3.1.6.
- 3.1.1 Weighing instrument. The balance or scale to be used to measure the resins and thirmer shall have a capacity great enough to weigh the materials and mixing container. The accuracy of the weighing instrument shall be  $\pm$  0.1 gram minimum.
- 3.1.2 Measuring vessel. The graduated measuring vessel to be used to measure the resins and thinners shall have a capacity great enough to measure the materials. The accuracy of the measuring vessel shall be  $\pm$  10 ml minimum.



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- 3.1.3 Mixing containers and stirrers. Mixing containers and stirrers shall be non-absorbtive and chemically compatible with the coating materials.
- 3.1.4 Spraying equipment. The spraying equipment shall be capable of applying a smooth and uniform coating of the polyurethane resin.
- 3.1.5 <u>Ouring oven</u>. The curing oven shall be electrically heated and capable of maintaining the desired temperature setting within  $\pm 3^{\circ}$ C ( $\pm 5^{\circ}$ F). The oven shall be equipped with a blower and suitable exhaust to provide air circulation and vapor removal.
- 3.1.6 <u>Heat lamps</u>. The heat lamps shall be capable of applying even heat to the required area.
- 3.2 <u>Materials</u>. The following materials, when processed and applied as specified herein, are approved for use by Raytheon ESD.
- 3.2.1 Elastomeric, Type 1. Elastomeric polyurethane coating per 929084-1, shelf life, in unopened containers is 12 months for Part A, and 6 months for Part B.
- 3.2.2 Topcoat, Type 2. Polyurethane coating per 929084-5.
- 3.2.3 Primer. Wash primer coating per 929084-2, shelf life, 6 months in unopened containers.
- 3.2.4 Thirner. 929084-3.
- 3.2.5 Chenglaze thirner. 929084-4.
- 3.2.6 Methyl Ethyl Ketone per TT-M-261
- 3.2.7 Toluene per TT-T-548.
- 3.2.8 Xylene per TT-X-916.

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3.2.9 Masking tape.

3.2.10 Sandpaper No. 320.

3.2.11 Isopropyl alcohol TT-I-735.

3.3 Required procedures and operations.

- 3.3.1 <u>Surface preparation</u>. The surface shall be scuff sanded with No. 320 sandpaper to remove the glossy finish.
- 3.3.2 <u>Cleaning</u>. The sanding dust shall be removed by wiping with a clean cloth and the surface washed with a lint-free wipe that has been immersed in Methyl Ethyl Ketore or other suitable solvents.
- 3.3.3 Masking. Mask all surfaces not to be painted with masking tape.
- 3.3.4 <u>Handling</u>. Keep surface free of all contaminates until painted. Paint as soon after surface preparation as possible. Parts not painted within 16 hours shall be recleaned with solvent.
- 3.3.5 Primer application.
- 3.3.5.1 The wash primer 929084-2, is supplied either in pre-measured kits or in bulk containers. For kits, pour entire contents of part "B" into part "A" and mix.
- 3.3.5.2 For bulk, thoroughly mix part "A" before removing it from its container. Mix the primer components in the following ratio:

	Parts by weight	Parts by volume
Part A	112	1
Part B	110	1

3.3.5.3 Thoroughly mix the resin components, and allow to stand for 15 minutes prior to use. Mix per Manufacturing Operating Instructions.



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- 3.3.5.4 Thin as required with methyl ethyl ketoreper TT-M-261 or Hughson thinner 929094-3. Approximately 15% thinner is recommended, but more may be used, if required, 25% maximum.
- 3.3.5.5 The pot life of the primer is 8 hours.
- 3.3.5.6 The primer shall be remixed before each use.
- 3.3.5.7 The ambient and substrate surface temperature shall be above  $15.6^{\circ}$ C (60°F).
- 3.3.5.8 Using suitable spray equipment apply the primer in single passes with about 50% overlap. Hold gun 8 to 10 inches from surface. parallel passes and spray 0.002 to 0.003 inch wet for a 0.00025 to 0.0005 inch dry film thickness. The desired dry film thickness will be achieved when the film is continuous, but mottled and translucent.
- 3.3.5.9 The primer will normally dry to touch in 30 to 60 minutes and may be topcoated in one hour and must be topcoated within 8 hours.
- 3.5.10 → The gun and spilled uncured resin shall be cleaned up by using methyl ethyl ketone, toluene or equivalent.
- Precautionary information. The solvents used in these coatings are volatile, combustible, and in some instances irritating to the skin. Keep containers tightly closed and away from heat and open flame. During application, all flames, welding and smoking shall be prohibited. Avoid prolonged breathing of vapors and contact with the In confined area, adequate ventilation should be provided during application and drying. When possible all work shall be done in a spray booth.

#### 3.3.6 Elastomeric, Type 1

3.3.6.1 929084 resins are supplied either in kits or bulk. For kits, mix the entire contents of parts A and B. For bulk, mix two parts by volume resin Part A (M 431) to one part by volume curing agent part B (M Proper mixing ratios are required,



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- 3.3.6.2 Thoroughly mix the resin components, thin and use.
- 3.3.6.3 Thin as required with equal parts of toluene per TT-T-548 and xylene per TT-X-916 or Chemglaze thinner 9951. Approximately 15% thinner is recommended but more may be used if required, 25% maximum.
- 3.3.6.4 The potlife of the elastomeric, Type I, coat is 2 hours.
- 3.3.6.5 The paint shall be applied by suitable spray equipment. Ambient and substrate surface temperature shall be above  $15.6^{\circ}C$  ( $60^{\circ}F$ ).
- 3.3.6.6 Apply a light flashcoat and let stand for 30 minutes.
- 3.3.6.7 Apply coating with a multiple pass spray technique with each pass at  $90^{\circ}$  to the previous coat is required with the final dry coat thickness of the topcoat to be between 0.002 and 0.003 inch.
- 3.3.6.8 When additional coats are required 1/2 to 2 hours should be allowed between coats.
- 3.3.6.9 The gun and spilled uncured resin shall be cleaned up with methyl ethyl ketone, toluene, xylene or equivalent.
- 3.3.6.10 Precautionary information. See 3.3.5.11.
- 3.3.7 <u>Cure.</u> The Elastomeric Type 1 coat may be cured using one of the following cycles.
- 3.3.7.1 Cure at room temperature for 7 days, parts may be handled after 6 hours at room temperature.
- 3.3.7.2 Dry at room temperature for 2 hours minimum and cure for 2 to 3 hours at  $93-124^{\circ}$ C ( $200^{\circ}-250^{\circ}$ F).
- 3.7.3 Dry at room temperature for 2 hours minimum and cure for 6 to 8 hours at  $66-82^{\circ}$ C ( $150^{\circ}-180^{\circ}$ F).



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### 3.3.8 <u>Rework</u>.

- 3.3.8.1 When repairs are required, the coating may be removed with methyl ethyl ketone or other suitable materials.
- 3.3.8.2 Rework the repair area as required, sand lightly with 320 sand-paper, feather edges, and thoroughly clean area with isopropyl alchohol.
- 3.3.8.3 Touch-up coat repair area per 3.3.3. through 3.3.7.3. When required, heat lamps may be used to cure the Elastomeric coating.
- 3.9 Topcoat, Type 2.
- 3.9.1 Thoroughly stir the contents of the can.
- 3.9.1.1 When thirming is required, a maximum of 25% by volume Xylene, Toluene, or 929084-4 thirmer may be used.
- 3.9.2 The gun and unused resin may be cleaned by using Methyl Ethyl Ketone, Acetone, Toluene, Mylene, or 929084-4 thinner.
- 3.9.3 The thirmed material shall be used within 16 hours.
- 3.9.4 Apply a light mist coat followed by a full wet coat.
- 3.9.5 Type 2 material relies upon atmospheric moisture to effect a cure. Do not apply when the relative humidity is less than 30% or greater than 60%.
- 3.9.6 Recoating shall be done between four and 24 hours.